

Work Order ID .57219

March 30, 2010 9:13:22 AM



Page 1

Item ID: D3827-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Inboard)

Stop



Start Date: 30/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 05/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date:

10-3-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3827	Rev A								

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c'sink as per dwg

4- remove identification markings

5- deburr

SAD 10-04-13

6- weld bushing in rib as per dwg D3827

A/R S.S. Rod Batch: *111629*

7- grind weld flush

8- deburr if necessary

6

pl 10.04.13

Work Order ID 57219

March 30, 2010 9:13:22 AM



Page 2

Item ID: D3827-041

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Setup Start



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Stop



Start Date: 30/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 05/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC10- Inspect visual per QSI004- ground welds

0.00

S 10/04/19



QC

Memo

0.00

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00

S 10/04/19



QC

Memo

0.00

Quality Control



150

Identify as per dwg & Stock Location: WA

0.00

SAD



Packaging

Memo

0.00

10-04-17

Packaging



Work Order ID 57219

March 30, 2010 9:13:22 AM



Page 3

Item ID: D3827-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Inboard)

Start Date: 30/03/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 05/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/2010

MF
10-4-20

Picklist Print

March 30, 2010 9:13:26 AM

Page 1

Work Order ID: 57219

Parent Item: D3827-041

Parent Item Name: Rib Assembly (Inboard)

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Date: 30/03/2010

Required Date: 05/04/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3759-1		Manufactured	No			100	Each	13.0000	18.0000			
---------	--	--------------	----	--	--	-----	------	---------	---------	--	--	--



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

13

53442

2

54072

9

55789

1

56143

1

M304TS0.750W.065

Purchased

No

100

f

638.1112 50.5263



304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

638.1111759

112398

0.0000047

113082

0.00419

113245

8.40038421

113683

0.30855

113836

0.000047

113956

29.398

114137

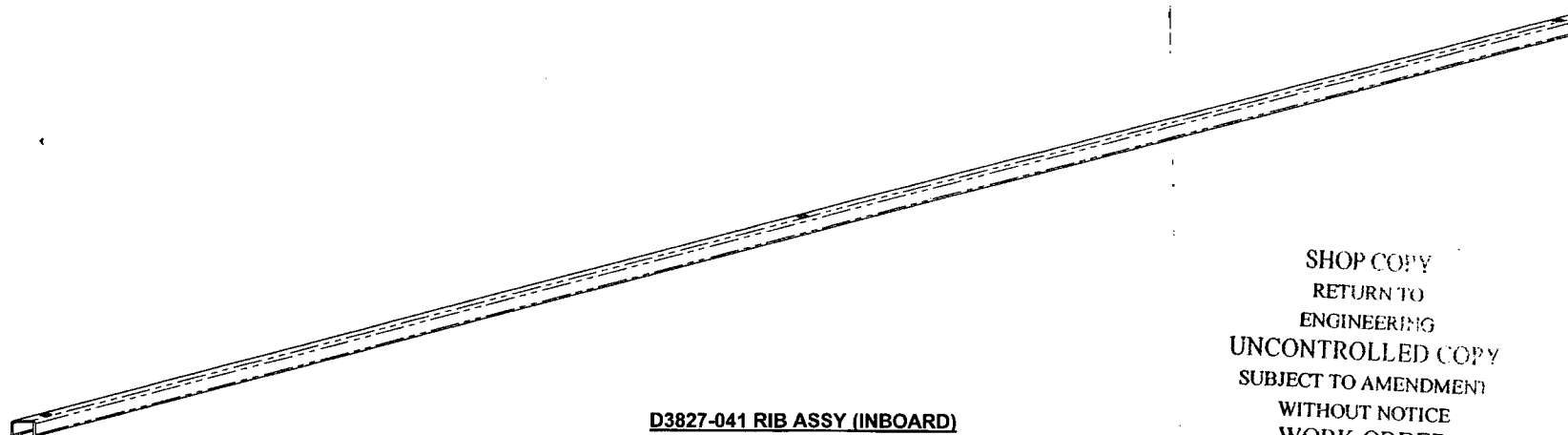
600

B57184 → ②
B57595 → ①⑥

SAD 10-04-13

50.5263

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB



D3827-041 RIB ASSY (INBOARD)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57219

10-3-30
RELEASED
08/11/16

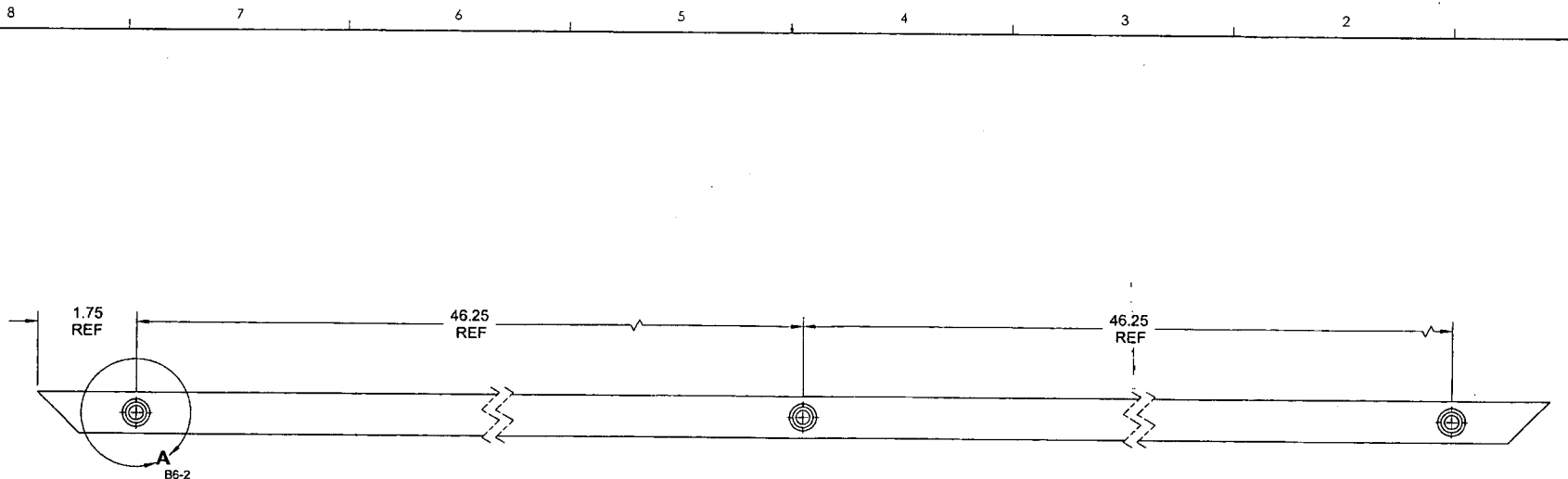
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 4.59 lbs

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

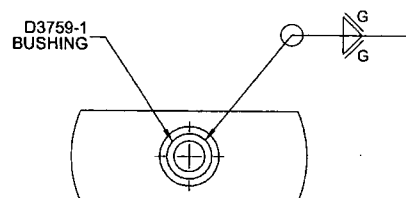
DRAWING NO. D3827
REV. A
SHEET 1 OF 3
TITLE RIB ASSY (INBOARD)
SCALE NTS

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D3827-041 RIB ASSY (INBOARD)

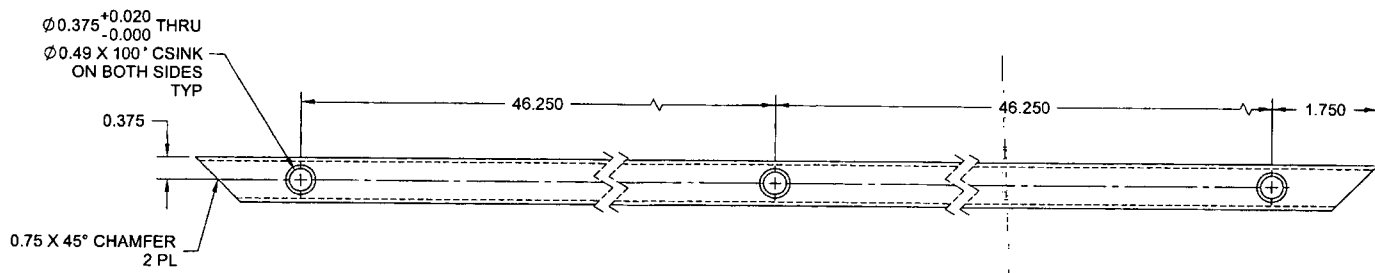
57219



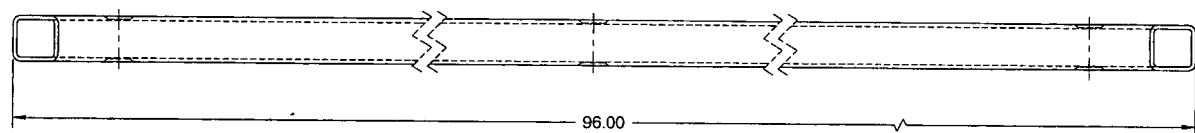
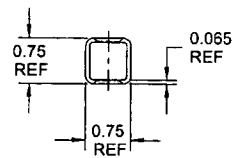
DETAIL A
SCALE 2X
C7-2
3 PL

RELEASED
08/11/18 N47

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57219



D3827-1 RIB

RELEASED
08/11/23

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.55 lbs

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 3 OF 3
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